

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020008**Date Inspected:** 25-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA**CWI Name:** Mr. Li Ming Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG TRIAL ASSEMBLY & bay 14**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY#14:

SEGMENT 14W:

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3020D-052(14W, Bottom plate and floor beam), And Critical Welding Repair Report (CWR) B-CWR2734 Rev.1, and Welder is identified as 066038; ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3020E-056(14W, Bottom plate and floor beam), And Critical Welding Repair Report (CWR) B-CWR2734 Rev.1, and Welder is identified as 066398; ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G (2F)-FCM-Repair-1.

# WELDING INSPECTION REPORT

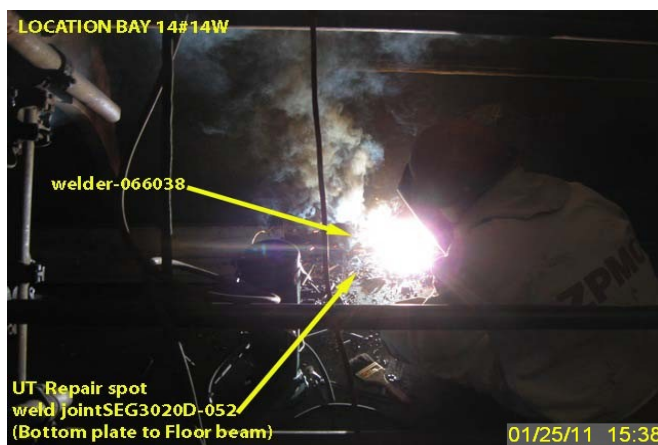
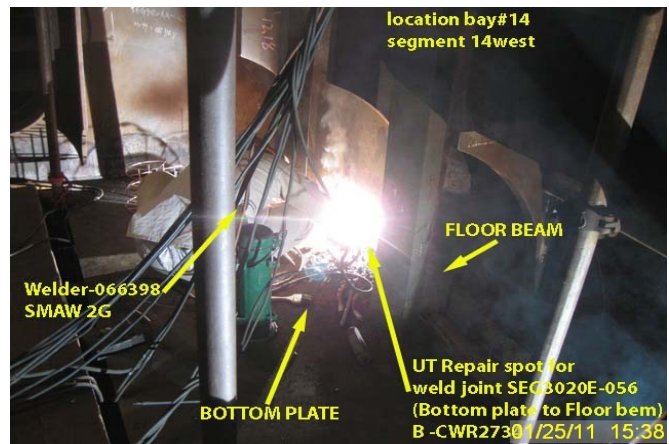
( Continued Page 2 of 3 )

Shielded Metal Arc (SMAW) welding of Weld Joint AH3002A-029,030(13AW), And Welder is identified as 067572; ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-P-2213-TC-U4b-FCM-1.

OBG Trial assembly area:

ABF QA Inspector performing Ultrasonic Testing (UT) for the Side plate to side plate weld joint OBW12E-002& 003 Located on 12BW+12CW Side plate CB SIDE.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



## Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

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| <b>Inspected By:</b> | Tharikoppada,Reddy | Quality Assurance Inspector |
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| <b>Reviewed By:</b> | Miller,Mark | QA Reviewer |
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